

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014533**Date Inspected:** 13-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao/ Zhou cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 3G-003 located on PCMK SEG3005C of Segment 12BW welder is identified as 202122. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint 3G-009 located on PCMK SEG3005D of Segment 12BW welder is identified as 201215. ZPMC QC is identified as Mr. Zhong yong gang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW repair welding of weld joint 2G-046 located on PCMK SEG3004X of Segment 12BW welder is identified as 066326. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-G(2F)-FCM-Repair and approved CWR1498.

OUTSIDE SHOP

10CE

SMAW welding of weld joint 3F-012 located on PCMK OBE10A of Segment 10CE welder is identified as 043661. ZPMC QC is identified as Mr.Li ping. The welding variables recorded by QC appeared to Comply with

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the WPS-B-P-2213-FCM-1.

FCAW welding of weld joint 2G-165 located on PCMK FB020-005 of Segment 11BE welder is identified as 055564. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2232-Tc-U4b-F.

11BE

SMAW repair welding of weld joint 3G-004 located on PCMK SSD17-PP99 of Segment 11BE welder is identified as 201087. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G(3F)-FCM-Repair and WR9685.

SMAW welding of weld joint 4G-252 located on PCMK SSD18A-PP100 of Segment 11BE welder is identified as 068097. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

10AW

ZPMC QC NDT personnel doing their MT segment tagging in hold back area on FL-3 side.

BAY#19

FCAW welding of weld joint 3F-015 located on PCMK SB019-070 of Lift 8 welder is identified as 062749. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 2G-049 located on PCMK SB015-068 welder is identified as 062788. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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